

Work Order ID 50578

July 16, 2009 8:19:32 AM



Page 1

Item ID: D3836-041

Accept



Setup Start



Revision ID: A

Item Name: Rib Assembly (Basket Lid, LH)

Stop



Start Date: 07/17/2009 Start Qty: 2.00



Cust Item ID:

Required Date: 07/22/2009 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan: MF

Date: 09-07-16

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3836

Rev A

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- cut D3836-1 and D3836-3 rib as per dwg D3836 2- remove identification markings 3- deburr

SAN 09-07-22

(Qty 2)

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

=> 8/07/22

(+2)

120

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- weld D3836-1 to D3836-3 and drill hole (3/16") using DT9447 jig and open to finish size as per dwg D3836 2- weld D2327-3 spacer bushing as per dwg D3836 3- A/R ER316 S.S. Rod Batch: M108160 3- grind weld flush where indicated on dwg D

PD

09-07-23

(2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 50578

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Page 2

Item ID: D3836-041

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Setup Start



Revision ID: A

Stop



Item Name: Rib Assembly (Basket Lid, LH)

Start Date: 07/17/2009 Start Qty: 2.00



Cust Item ID:

Required Date: 07/22/2009 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

Cpl 09.07.23

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

=> 5 02/07/23



4

150

Identify as per dwg & Stock Location: Basket

0.00



Packaging

Memo

0.00

Packaging

PD 09.07.23



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 50578

July 16, 2009 8:19:32 AM

Page 3

Item ID: D3836-041

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Revision ID: A

Item Name: Rib Assembly (Basket Lid, LH)

Setup Start

Stop

Start Date: 07/17/2009 Start Qty: 2.00

Required Date: 07/22/2009 Req'd Qty: 2.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/07/24 JF

MF 09-07-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

July 16, 2009 8:19:31 AM

Page 1

Work Order ID: 50578

Parent Item: D3836-041RevA

Parent Item Name: Rib Assembly (Basket Lid, LH)

Start Date: 07/17/2009

Required Date: 07/22/2009

Comments:

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2327-3RevD		Manufactured	No			100	Each	76.0000	2.0000			
Spacer Bushing												

Warehouse
Location

Loc Qty

Loc Code

Premier

Mezz

78

44274

69

44365

9

Main Warehouse

ST

-2

44274

-2

M304TS0.750W.065

Purchased

No

100

f

174.1729

3.7491



304 SQ Tube .75x.75x.065W

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

MAT

174.172879

110969

3.29

111148

15.96

111331

1.96

111432

0.44

111885

5.9122

112051

146.610679

3.7491

SAD 07-07-22 (Qty 2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

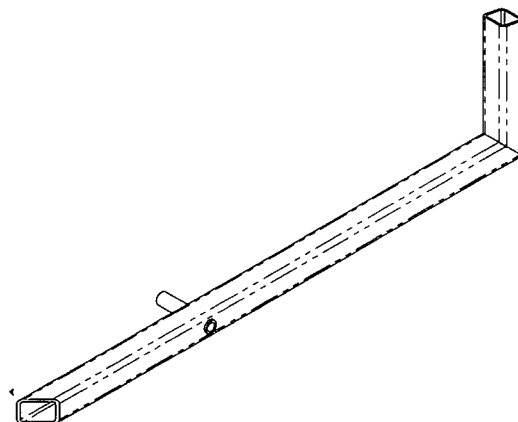
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QA: N/C Closed: _____ Date: _____

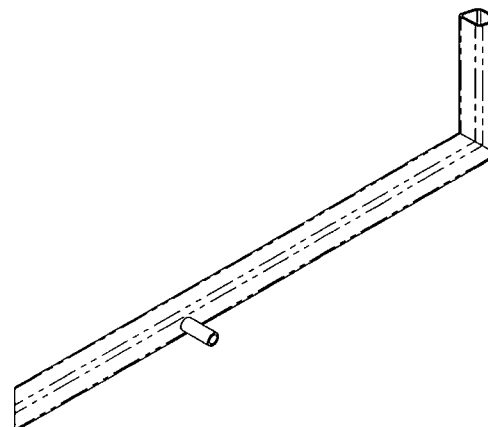
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3836-041	RIB ASSY (BASKET LID, LH)
2		X	D3836-042	RIB ASSY (BASKET LID, RH)
3	1	1	D2327-3	SPACER BUSHING
4	1		D3836-1	RIB
5		1	D3836-2	RIB
6	1	1	D3836-3	RIB



D3836-042 RIB ASSY (BASKET LID, RH)



D3836-041 RIB ASSY (BASKET LID, LH)

SHOP COPY
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 50578
MF 09-07-16

RELEASED
08/11/18 MB

- NOTES:
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.99 lbs EACH
8) WELD PER DART QSI 004

A	NEW ISSUE	MB	08.09.24
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.09.24		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3836** REV. A
SHEET 1 OF 3

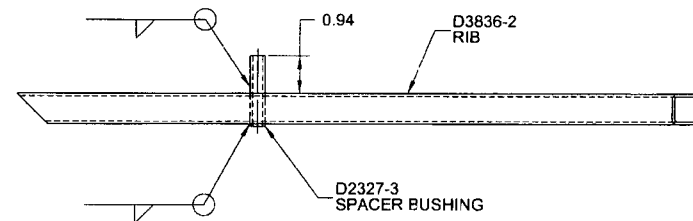
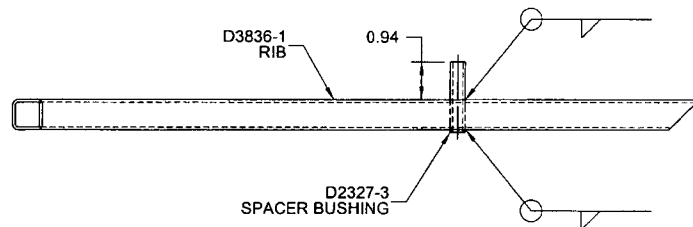
TITLE **RIB ASSY (BASKET LID)** SCALE NTS

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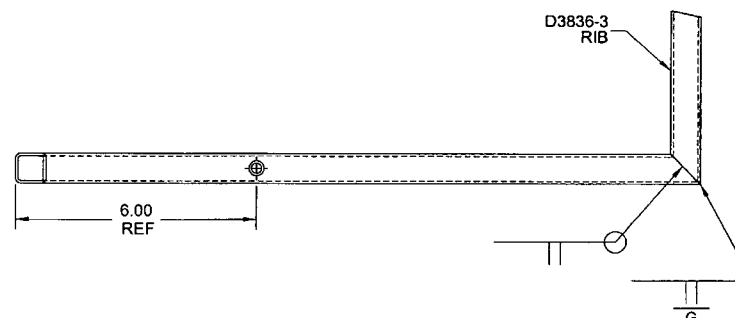
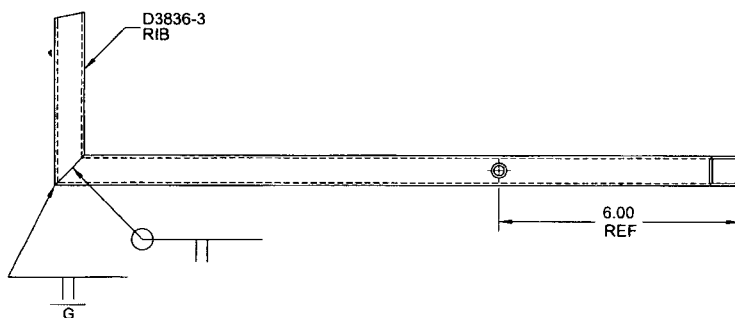
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C

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B

B

D3836-041 RIB ASSY (BASKET LID, LH)

D3836-042 RIB ASSY (BASKET LID, RH)

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WORK ORDER
50576
MF 09-07-16

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08/11/18

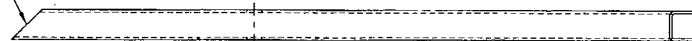
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A

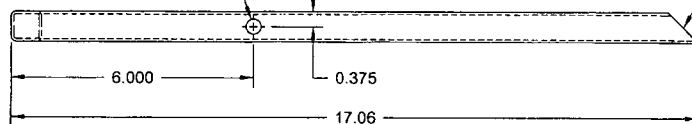
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DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3836	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		RIB ASSY (BASKET LID)	NTS
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8 7 6 5 4 3 2 1

0.75 X 45°
CHAMFER

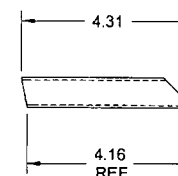


$\phi 0.375^{+0.020}_{-0.000}$ THRU



D3836-1 RIB

0.75 X 45°
CHAMFER



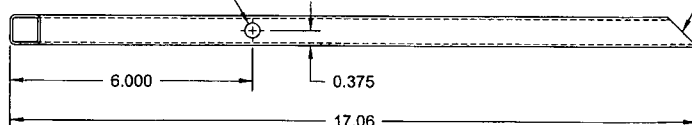
0.75 X 45°
CHAMFER

D3836-3 RIB

0.75 X 45°
CHAMFER

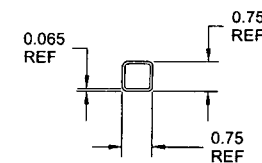


$\phi 0.375^{+0.020}_{-0.000}$ THRU



D3836-2 RIB

0.75 X 45°
CHAMFER



**TYPICAL SECTION
VIEW**

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WORK ORDER
NO. 50578
MF 09-07-16

RELEASED
08/11/18

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3836-1/2 = 0.78 lbs EACH; D3836-3 = 0.19 lbs

DESIGN	<i>16</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>ASS</i>	DRAWING NO. D3836	REV. A
CHECKED	<i>ASS</i>	SHEET 3 OF 3	
MFG. APPR.	<i>MF</i>	TITLE	SCALE
APPROVED	<i>MF</i>	RIB ASSY (BASKET LID)	NTS
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